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SPLIT

DART AEROSPACE LTD	Work Order:	19666 <b>OF</b>
Description: Fwd Crosstube	Part Number:	D2889
Drawing: D2889 Rev. B; D6005 Rev. A	Qty:	19
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <i>Dwg. not required RF 02.11.05</i>	<i>HJ</i>	03.09.19	19
2	PG	Issue P/O: <i>70051005</i> a) Extrude as per Dwg D6005 length = 180" (Ref. D6005-180) b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) ) Seamless aluminum tube c) Minimum ultimate tensile strength = 77ksi d) Minimum tensile yield strength = 66ksi e) Material certification required		03.09.22	19
3	RG	Receive and inspect for transit damage <b>Ensure material certification attached</b>	<i>Q</i>	04.01.05	22
4	QC6	Inspect dimensions as per Dwg D6005 and check 180" length	<i>Ph</i>	04.02.11	22 <i>PTO</i>
5	FP	Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube	<i>2</i>	07.02.11	22 <i>5432</i>
6	LG	Bend as per Dwg D2889 and Folio FT001 <b>Sign Page 2</b>			
7	QC6	Inspect dimensions per Dwg D2889 <b>Sign Page 2</b>			
8	LG	Deburr and Polish <b>Sign Page 2</b>			
9	FP	Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube <b>Sign Page 2</b>			
10	QC5	Inspect work to Step 9 <b>Sign Page 2</b>			
11	ST	Identify and stock	<i>DP</i>	05/03/07	1
12	AC	Cost / part: <i>786.08</i>	<i>SUC</i>	05.04.21	1
13	DC	Close W/O <i>786.08</i> Inspect Level 21	<i>HJ</i>	05.04.25	1

See ATTACHED  
Sheet 2  
*HJ*

Rev	Date	Change	Revised By	Approved
A	99.05.31	New Issue, ECN 200	DM	
B	00.04.11	Remove Painting step	EC	
C	02.10.18	Re-format; Added spec	KJ <i>RT</i>	<i>JA</i>

RELEASED  
02/10/130 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 19666		WORK ORDER NON-CONFORMANCE 02889					
DATE	STEP	Description of NC section A	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial				
04-02-11	4	Dimensions should be actual dimensions $\varnothing 2.750$ OD $\varnothing 2.000$ ID $0.375$ Wall Variance between $0.375$ " and $0.361$ "	$\varnothing 2.741$ OD $\varnothing 2.000$ ID Wall acceptable OD only $0.003$ " out of tolerance used on Extended gear find tubes. - QC. (per D6005, OD is $\pm 0.006$ wall is $\pm 0.015$ )	B 04-02-11	B 04-02-11	# 04-02-11	B 04-02-11
	6	TUBE IS OVERSIZED	SCRAP	# 04-05-11	N/A	# 04-05-11	

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O Step	A	B	C	D	E	F	G	H	I	J	K	L
6	OP 04/05/11	OP 04/05/11	OP 04/05/11	DP 04/05/11	DP 04/05/11	DP 05/23/02	DP 05/23/02					
7	OP 04/05/11	OP 04/05/11	OP 04/05/11	DP 04/05/11	DP 04/05/11	DP 05/23/02	DP 05/23/02					
8						DP 05/23/02	DP 05/23/02					
9						DP 05/23/02	DP 05/23/02					
10						DP 05/23/02	DP 05/23/02					

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Save ED for D705-596-101  
 SPAN is 119.125" angles 57°, 57°

RELEASED  
 02/10/30 RF